# Work Order ID 62620 October 5, 2010 11:48:02 AM

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Page 1

Item ID: Revision ID:	D206-642-441		7	Accept					Setup	Start		
Item Name:	Replacement Sk	idtube	_							Stop		
Start Date:	10/05/10	Start Qty: 1.00			Cust Item I	D:						
Required Date	: 10/22/10	<b>Req'd Qty:</b> 1.00			Customer:							
Reference:												
Approvals:	Process Plan	:	Date: 10-10-6	Tooling:	Da	ate:	_	F	Run	Start		
	QC:		Date:	_ SPC (Y/N):	Da	ate:				Stop		
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		leject lumber	Insp. Stamp
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October 5, 2010 11:48:02 AM

Item ID:

D206-642-441

**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

Required Date: 10/22/10

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date:\_\_\_\_\_

Date: Tooling:

Accept

SPC (Y/N):

Set Up/

0.00

0.00

**Run Hours** 

Tool ID

Tool # Plan

Date:

Date:

Code

Accept **Qty** 

Run

Reject **Qty** 

Setup Start

Stop

Start

Stop

Reject Number

Insp. Stamp

110

Skidtubes

Sequence ID/

**Work Center ID** 

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as

A/R□□Aluminum Rod□ 171/5

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube





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W/O:	** ** .		W	ORK ORDER CHAN	GES						
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#### Work Order ID 62620

October 5, 2010 11:48:07 AM



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Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Date:

Run

Stop

Start



Sequence ID/

**Work Center ID** 

115

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Memo

Set Up/ **Run Hours** 

0.00

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Tool ID

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

116

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

Pilolois

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

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#### Work Order ID 62620

October 5, 2010 11:48:07 AM

Required Date: 10/22/10



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Item ID:

D206-642-441

Accept

Setup Start

Stop

Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00

Operation

Description

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date:

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Tool ID

Tool # Plan

Code

Accept

Reject

Reject

Insp.

Work Center ID 130

Sequence ID/

Quality Control

Memo

QC3- Inspect Part Finish

0.00

0.00

Date:

Date:

Qty

Qty

Run

Number

Stamp

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Required Date: 10/22/10

Item ID:

D206-642-441

Accept



Setup Start



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

Date: Date: Run

Start Stop

Stop



Sequence ID/

**Work Center ID** 

QC:

Operation Description

Skidtubes

Set Up/ **Run Hours**  **Tool ID** 

Tool # Plan Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

140

Skidtubes Skidtubes

Memo

0.00

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: (9/10/21) Time:□

Finish Date: 101 Time: 3:00 pm

A/R Site flex-291 | MUS/14/ Sikaflex expiry tiate | 11/01/04





W/O:			WORK ORDER CHANGES								
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#### Work Order ID 62620

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Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Required Date: 10/22/10

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Date:

Tooling:

0.00

0.00

0.00

SPC (Y/N):

Date:

**Tool ID** 

Date:

Run Start

Stop



Sequence ID/

**Work Center ID** 

150

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

0.00

> 10/10/25

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

160

Skidtubes Skidtubes

Skidtubes

Memo

Memo

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the

other side. Use aluminum rod.

A/R Aluminum Rod M11385

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per 10 of D2650 Debur

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#### Work Order ID 62620

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Item ID:

D206-642-441

Accept



Setup Start

Stop

Stop



**Revision ID:** 

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:\_\_\_\_\_

Tooling:

Date:

Date:

Start Run

Reject

Qty



Date:

**SPC (Y/N):** 

Set Up/

0.00

**Run Hours** 

Tool ID

Tool # Plan

Code

Accept Qty

Reject Number

Insp. Stamp

**Work Center ID** 

170

Sequence ID/

Skidtubes Skidtubes

Operation -**Description** 

HandFinishing

Install D2680-041 Nut Plate as per Dwg D2650

0.00

180

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

190



**Quality Control** 

QC5- Inspect part completeness to step on W/O

Memo

0.00

W/O:			V	GES						
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#### Work Order ID 62620

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Item ID:

D206-642-441

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

**Req'd Qty:** 1.00



Date:\_\_\_\_\_

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run



Sequence ID/

**Work Center ID** 

200

HandFinish

Hand Finishing

Operation Description

Pressure Wash per QSI005 4.3

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty Oty

Reject Number

Insp. Stamp

10/10/79

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in .

211

SprayPaint

**Spray Painting** 

0.00

PRIME B 115967PAINT DELFLEET BLUE B 115509CLEAR DELFLEET B 115949

0.00

ml 10 11 03

221

Quality Control

QC14- Inspect Spray Paint

Memo

Memo

0.00

77 10-11-04 (

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#### Work Order ID 62620

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**Revision ID:** Item Name:

Item ID:

D206-642-441

Replacement Skidtube

**Start Date:** Required Date: 10/22/10

10/05/10 Start Qty: 1.00

Req'd Qty: 1.00



Accept



Setup Start

Stop



Reference:

Approvals: Process F	'la
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QC:

Date:\_\_\_\_\_

Tooling: Date:

SPC (Y/N):

Date: Date:

Start Run

Qty



Stop

Sequence ID/

Work Center ID

230



HandFinish

Hand Finishing

**Operation Description** 

HandFinishing

Set Up/ **Run Hours** 

**Cust Item ID:** 

**Customer:** 

Tool ID

Code

Tool # Plan

Qty

Accept

Reject Reject Number

Insp. Stamp

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R DSikaflex-291 A/VI 40 93 Sikaflex expiry date: 10/10

-2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R□Sikaflex-291□ M//14 OFF 3 Sikaflex expiry date:□ 10/10

6-Wing Walk as no Dwg D2650-7 and QSI 005 4.4 [ Batch: MIS 790

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#### Work Order ID 62620

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Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

0.00

0.00

0.00

0.00

Date:

Date:

Run

Stop

Start



Sequence ID/ **Work Center ID** 

240

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Date:

Set Up/ Tool ID **Run Hours** 

Tool # Plan

Accept Code Qty

Reject

Reject Number

Insp. Stamp

250

Packaging

Packaging

Packaging

Memo

Memo

Identify and pack for shipping as per PPP D206-642-441

Location:\_\_\_\_

PPP Rev:

260

**Quality Control** 

QC21- Final Inspection - Work Order Release

Memo

1211/161

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W/O:			V	VORK ORDER CHAN	GES					
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October 5, 2010 11:47:50 AM

Work Order ID: 62620

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM

IPP Rev:I 08-05-01 add QC3 DD verified by:EC

IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC

IPP rev K

10.09.27 SS washers for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			230	Each	1,214.000		60 H 01	ulou		
				<b>Location</b>		<u>Loc</u>	: Qty	Loc Code		•			
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AN960JD10L    <b>                                  </b>	NAS1149D0332J	Purchased	No			230	Each MII48	0.0000 SH	2	12 Jel	10/11/	5 C	
AN960JD416	NAS1149D0463J	Purchased	No			230 N	Each	24.0000 Z	1	1 x 1 H(	10/11/	၁ &	

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#### **Picklist Print**

October 5, 2010 11:47:50 AM

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Work Order ID: 62620

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube



**Start Date:** 10/05/10 Start Qty: 1.00

Required Date: 10/22/10

Required Qty: 1.00

CCR264SS3-3



Purchased

No

170

446.0000 Each

2

Cherry Rivet

CR3212-4-03

Purchased No ST311 112314 113539 113973

Location

Loc Qty 446 44 398

230 Each Loc Code

1,888.000

2

Cherry Rivet

	Location
	ST311
NT.	

Manufactured

Loc Oty 1888 111359 5 112314 2 114436 448 71 114456 114859 1362 110

Each



Loc Code

D2620



Skidtube, 206 Skidtube

Location

LG

61632

Loc Qty

Loc Code



W/O:			WO	RK ORDER CHA	NGES					
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NCR:		,	WORK ORDE	R NON-CONFOR	RMANCE	(NCR	)			
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#### **Picklist Print**

October 5, 2010 11:47:51 AM

Work Order ID: 62620

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube



**Start Date:** 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D2646



Aft Cap

(lan	utactured	

110

Each

50.0000



<u>Location</u>	<u>1</u>	<u>Lo</u>	c Oty	Loc Code		
FP-4			45	B62652		x \
	57332		45			
fp5			1			
	61752		1			
FP6			4			
	52663		4			
		140	Each	66.0000	1	1

D2647



Cap

Manufactured

Manufactured

<b>Location</b>	Loc	e Oty	Loc Code			
FP		66				- //
55352		66				BE 10/10/12
	170	Each	65.0000	23	23	/ //2
						,

D2649



Cross Bolt Spacer

Location Loc Qty LG 58545 60652

Loc Code

W/O:			W	ORK ORDER CHANG	SES						
DATE STEP		PRO	PROCEDURE CHANGE			Date	Qty	Approval, Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _			
Resolution:			Disposit	on:	QA: N/C Closed:				Date:		
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DATE	STEP	Description of NC			tion B	Verifi	cation	Approval	Approval		
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#### **Picklist Print** Page 4 October 5, 2010 11:47:51 AM Work Order ID: 62620 D206-642-441 Parent Item: Required Date: 10/22/10 Parent Item Name: Replacement Skidtube **Start Date:** 10/05/10 Required Qty: 1.00 Start Qty: 1.00 D2651-1 230 Manufactured No Each 622.0000 Plug Location Loc Qty Loc Code Y27 FP B62638 252 51530 152 61751 100 370 fpa 53349 235 57869 135 D2651-3 230 Each 626.0000 22 Manufactured No 16/11/00 O-Ring Location Loc Qty Loc Code FP 626 46114 130 61962 496 D2654-7 0.0000 Manufactured No 160 Each 362686 Web 29.0000 D2680-041 Manufactured 170 Each

**Nut Plate** 

Location

W/O:										
DATE	STEP	PROCEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Ye	s No I	DQA:	Date:		
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#### **Picklist Print**

October 5, 2010 11:47:52 AM

Work Order ID: 62620

D206-642-441 Parent Item:

Parent Item Name: Replacement Skidtube



61241

Location

FP18



Each

**Start Date:** 10/05/10

Required Date: 10/22/10

Page 5

Start Qty: 1.00

Required Qty: 1.00

D3535-15

Wearshoe

Manufactured

Manufactured

Loc Qty 6 6

230

230 Each

Loc Code B62707

6.0000

19.0000

Loc Code

9.0000

Wearshoe

D3535-23

Manufactured

Location Loc Oty FP 61830 7 FP021 20 60231 11 230

Each

Wearshoe

D3535-37

Manufactured No

FP

Location Loc Qty 9 9 56101 230 Each

10.0000

Loc Code

Gasket

D3536-15

Location		Loc Qty
FP.		9
	56055	1
	60875	8
FP11		1
	59238	1

Loc Code	
1362459	

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DATE	STEP	Description of NC		Section B Ve			Approval	Approval			
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			Chief Eng	Chief Eng	Date			Chief Eng	QO IIISPECIOI		
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			Chief Eng	Chief Eng	Date		etion G	Chief Eng	QO IIISPECIOI		
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#### **Picklist Print**

October 5, 2010 11:47:52 AM

Work Order ID: 62620

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 10/05/10

Required Date: 10/22/10

Page 6

Start Qty: 1.00

Required Qty: 1.00

D3536-23

Gasket

Manufactured

230

Each

8.0000

D3536-37



Gasket

Manufactured No 61237

Loc Qty 8 230 Each

Loc Code 1363341

8.0000

Location FP

Location

FP011

56102

Loc Qty

Loc Qty

Each

230

Loc Code

Loc Code

14.0000

Wearpad

D3537-1

Location FP

FP17

55465

57713

60491 61640

13 3 3

1362661

D3537-3



Manufactured

Manufactured

No

230

7 Each

8.0000

Location

FP17

60866

Loc Qty

W/O:		WORK ORDER CHANGES											
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	S	ign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector			
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#### **Picklist Print**

Page 7

October 5, 2010 11:47:53 AM Work Order ID: 62620 Parent Item: D206-642-441 Parent Item Name: Replacement Skidtube Required Date: 10/22/10 **Start Date:** 10/05/10 Required Qty: 1.00 Start Qty: 1.00 MS27039-1-08 1,585.000 Purchased No 230 Each 10/11/08 Screw Location Loc Qty Loc Code ST291 1585 110835 473 114718 112 115108 1000 MS27039-4-06 No 230 108.0000 Purchased Each Screw Location Loc Qty Loc Code ST292 108 109061 14 115460 94 MS27039C1-08 Purchased No 230 Each 1,077.000 60 10/11/08 **SCREW** Location Loc Qty Loc Code M116022 Y60 FP 276 115336 276 ST293 801 115589 800 19185

W/O:	WORK ORDER CHANGES												
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#### **Picklist Print**

October 5, 2010 11:47:53 AM

Work Order ID: 62620

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 10/05/10

Required Date: 10/22/10

Page 8

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Washer

Purchased

No

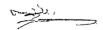
230

5,239.000 Each

10/11/08

<b>Location</b>	Loc Qty	Loc Code	
ST297	5239		
113524	10		
113737	150		
115000	125		
115698	78		
115816	1276		·
115832	3600		<u> </u>









W/O:			WORK ORDER CHANGES									
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QTY QTY QTY QTY PART NUMBER DESCRIPTION х D2650-1 SKIDTUBE ASSEMBLY х D2650-3 SKIDTUBE ASSEMBLY D2650-5 х SKIDTUBE ASSEMBLY X D2650-7 SKIDTUBE ASSEMBLY 1 D2600-1-160 **EXTRUSION** D2654-1 WEB D2654-3 WEB D2654-5 WEB D2654-7 WEB D2646 AFT CAP D2647 CAP 17 18 19 23 D2649 CROSS BOLT SPACER 16 18 14 22 D2651-1 PLUG 16 18 14 22 D2651-3 O-RING D2680-041 NUT PLATE 2 2 D3286-1 DOUBLER 2 2 D3286-3 STUD 42 44 54 ALS7-1032-130 INSERT (or AK\$4-1032-130, AL\$4-1032-130, ALS7-1032-130) 2 2 2 2 AN960JD10L WASHER 2 2 2 2 CCR264SS3-3 RIVET 2 2 CR3212-4-03 RIVET 2 2 2 2 2 2 MS27039-1-08 SCREW MS27039-4-06 SCREW AN960JD416 WASHER 1 52 52 CR3212-4-04 RIVET

UNCONTA SUBJECT NO. 200-00-05

DELEASE

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C

В

1) MATERIAL: N/A

2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150° IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS, SHT 6 ADDED, ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7. (SEE NOR 239).	AJ\$	08.08.08			
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30			
D	REDRAW; INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	СР	04.05.17			
n	CHANGE HOLE PATTERN AND FRONT END DS 97.1					
8	AS MANUFACTURED CHANGES	DS	97.06.26			
Α	NEW ISSUE	DŞ	97.03.25			
REV.	DESCRIPTION BY DATE					
DESIGN	DS DART AFROSPAC	FIIS	A INC			

DEGIGN	l no	J DAKT AEKUSPAUL USA	A. INC. I
DRAWN	AµS	PORT HADLOCK, WA	"…
CHECKED	_	DRAWING NO.	REV. F
MFG. APPR.	8	D2650 S⊦	EET 1 OF 6
APPROVED	10	TITLE	SCALE
DE APPR.	-	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE 08.0	8.08	COPYRIGHT © 1997 BY DART AEROSPACE USA THIS COCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS I NOT TO BE USED FOR MAY PURPOSE OR COPIED OR COMMUNICATED TO MAY OTHER WITTEN PRIVASSON PROM DART AEROSPACE USA. INC.	CHDITION THAT IT IS

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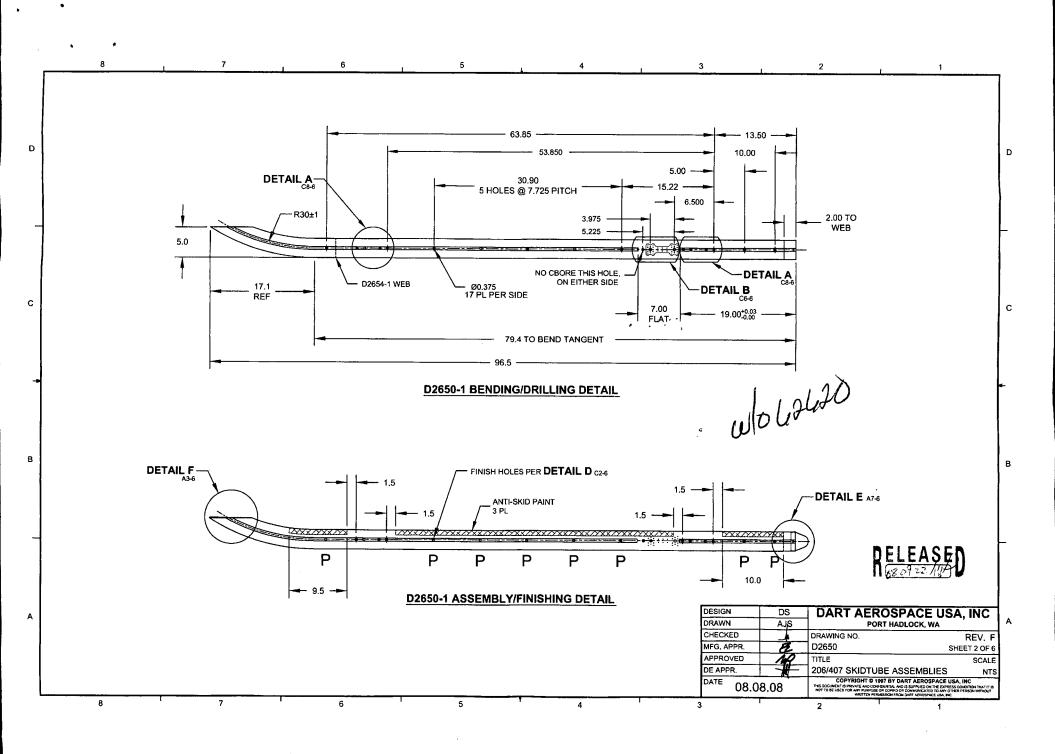
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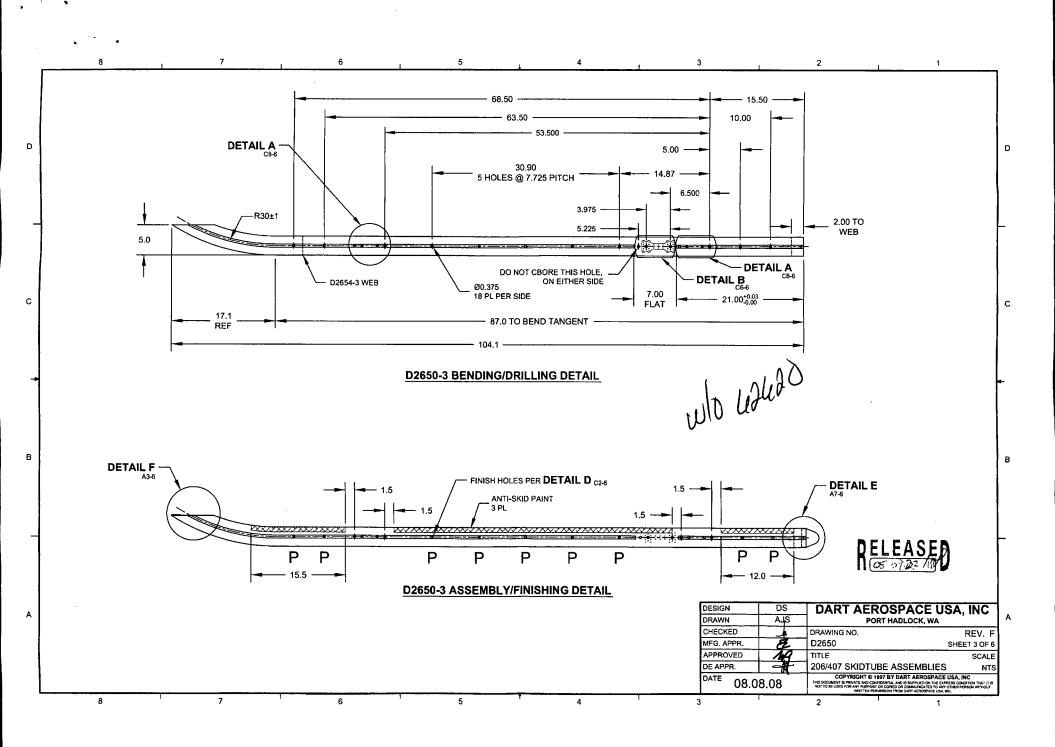
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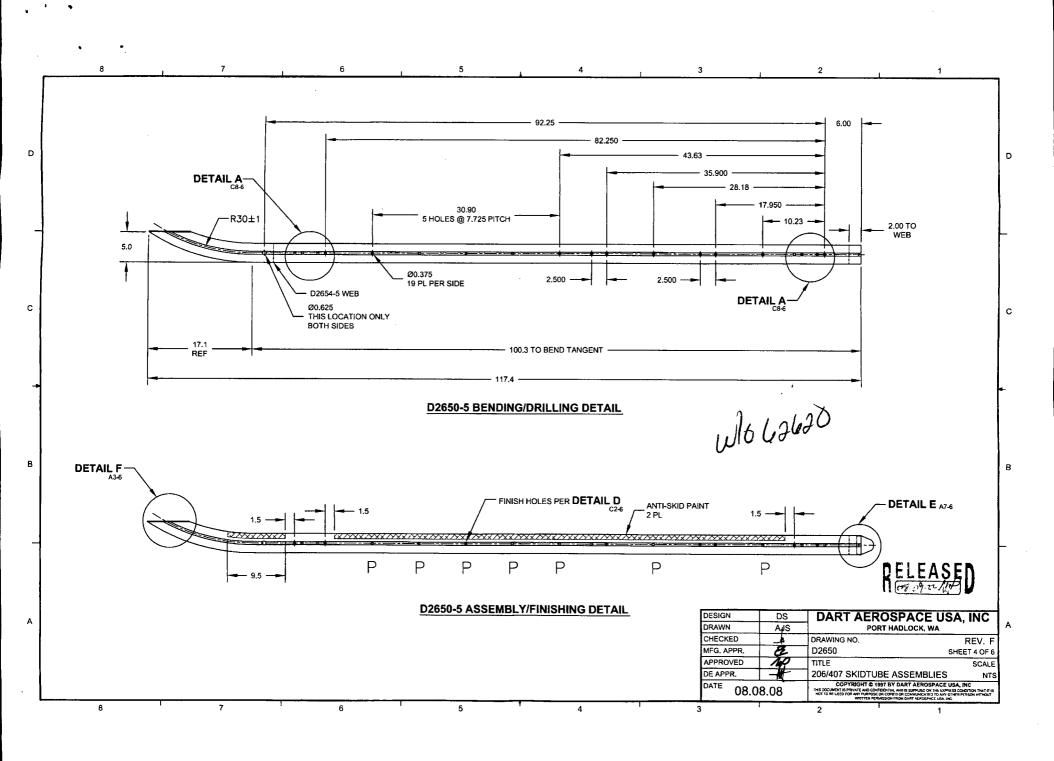


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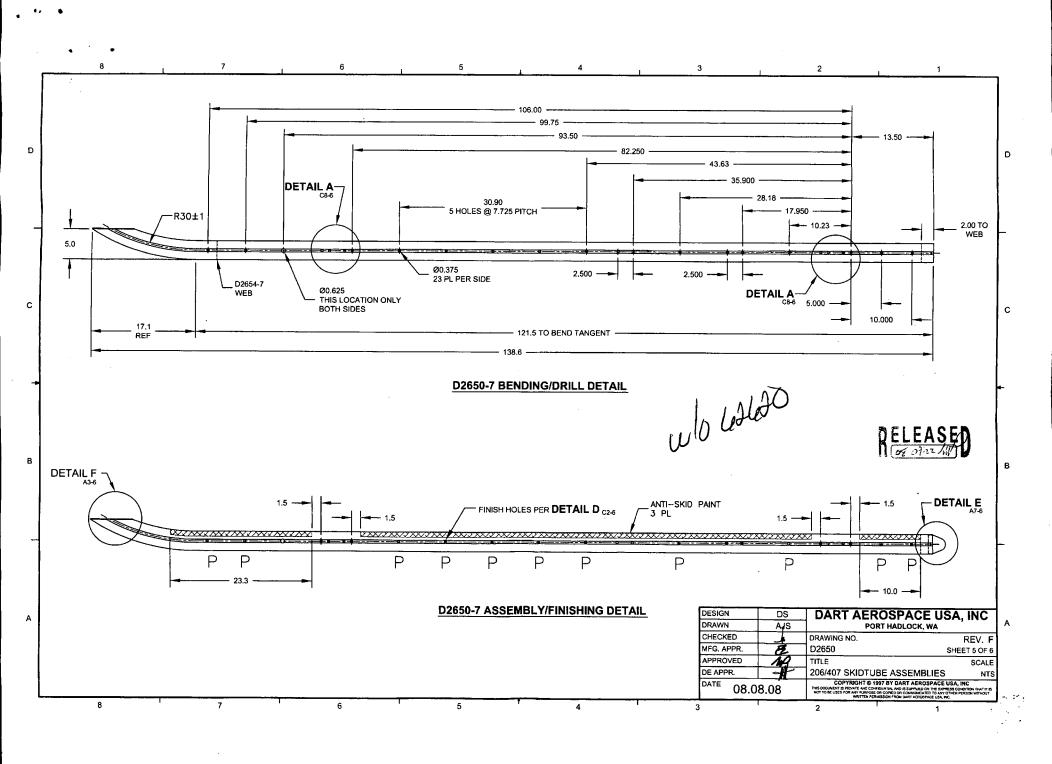


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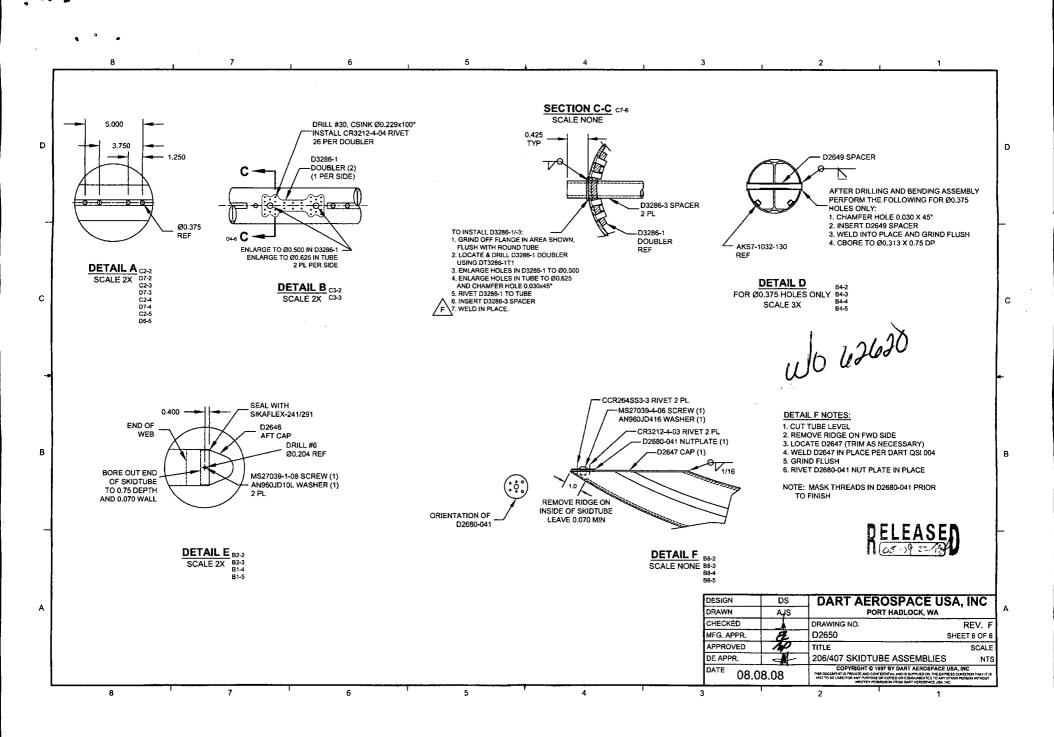
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NO. 241

# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Banday Elliott		
Job number: 622808		
Part number: DAO6 642 · 541		
Description: 206 skid		
Welding Process: Tig[ Mig[ ]		•,
Base materiel: Aum 10140	. · ·	
Current: AC DC ]		

## TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[i] fail[] pass[] fail[]
<u>UNACCEPTABLE</u>	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier Salay Elliot	Date of Test Coupon 10.09.30  Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.